

Date: Monday, 03/11/2008 1:30:47 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GUIDE
Job Number : 43167	
Estimate Number : 11216	
P.O. Number :	Part Number : D33335
This Issue : 03/11/2008 S.O. No. :	Drawing Number : D3333 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 42473	Material :
Written By :	Due Date : 15/11/2008
Checked & Approved By : <u>JLD 08 11 03</u>	Qty: 10 Um: Each
Comment : Est. A05.01.13 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B1500X01000	1010-1025 Steel Bar 1.500 x 1.00
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Comment: Qty.: 0.6672 f(s)/Unit Total: 6.6717 f(s)
 AISI 1010-1025 Steel Bar
 Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel
 (M1010-B1.500x01.000)
 Identify for D3333-5
 Batch: 108150

2.5 08/11/06 (6)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 1.500" x 1.000" thick x 7.500" long

2.5 08/11/06 (6)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA484 and Dwg D3333
 Tap holes as per Dwg D3333
 Deburr
 Identify as D3333-5

2.5 08/11/07 (6)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2.5 08/11/07 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 03/11/2008 1:30:47 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 43167

Part Number: D33335

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 08/11/09

(6)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- pass parts in deburring machine

Cpl 08/11/11

(6)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/11/11 (6)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Ensure to mask threaded holes

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:30 OF
320
2:00

mk 08/11/14

(6x)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/11/14

SP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *404*

8/11/14

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/17

Job Completion



u 08/11/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

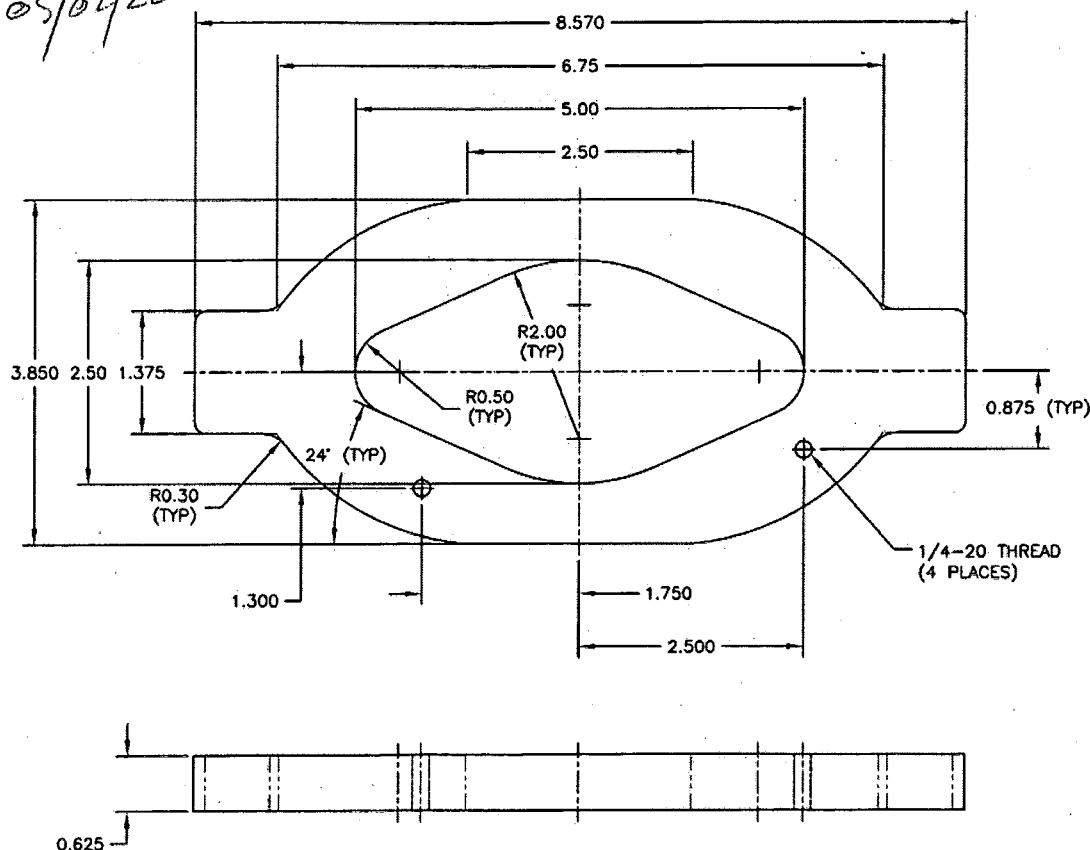
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED [Signature]	DRAWING NO. D3333	REV. B SHEET 1 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:2
A	04.12.14	NEW ISSUE	
B	05.02.18	RE-DESIGN D3333-3	

RELEASED
[Signature]
05/02/22



D3333-1 BASE PLATE PANEL

NOTES:

- 1) MATERIAL: AISI 4140 STEEL 0.625 THICK STEEL (REF. DART SPEC. M4140-B)
MIN. YIELD TENSILE STRENGTH = 100 ksi
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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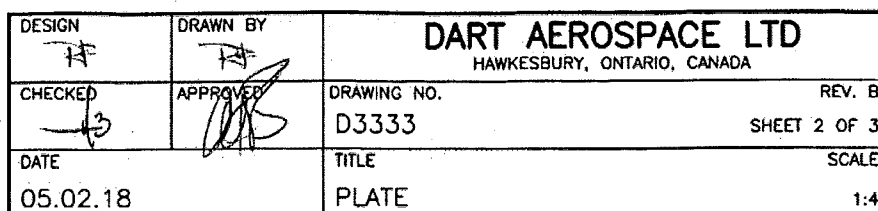
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WORK ORDER

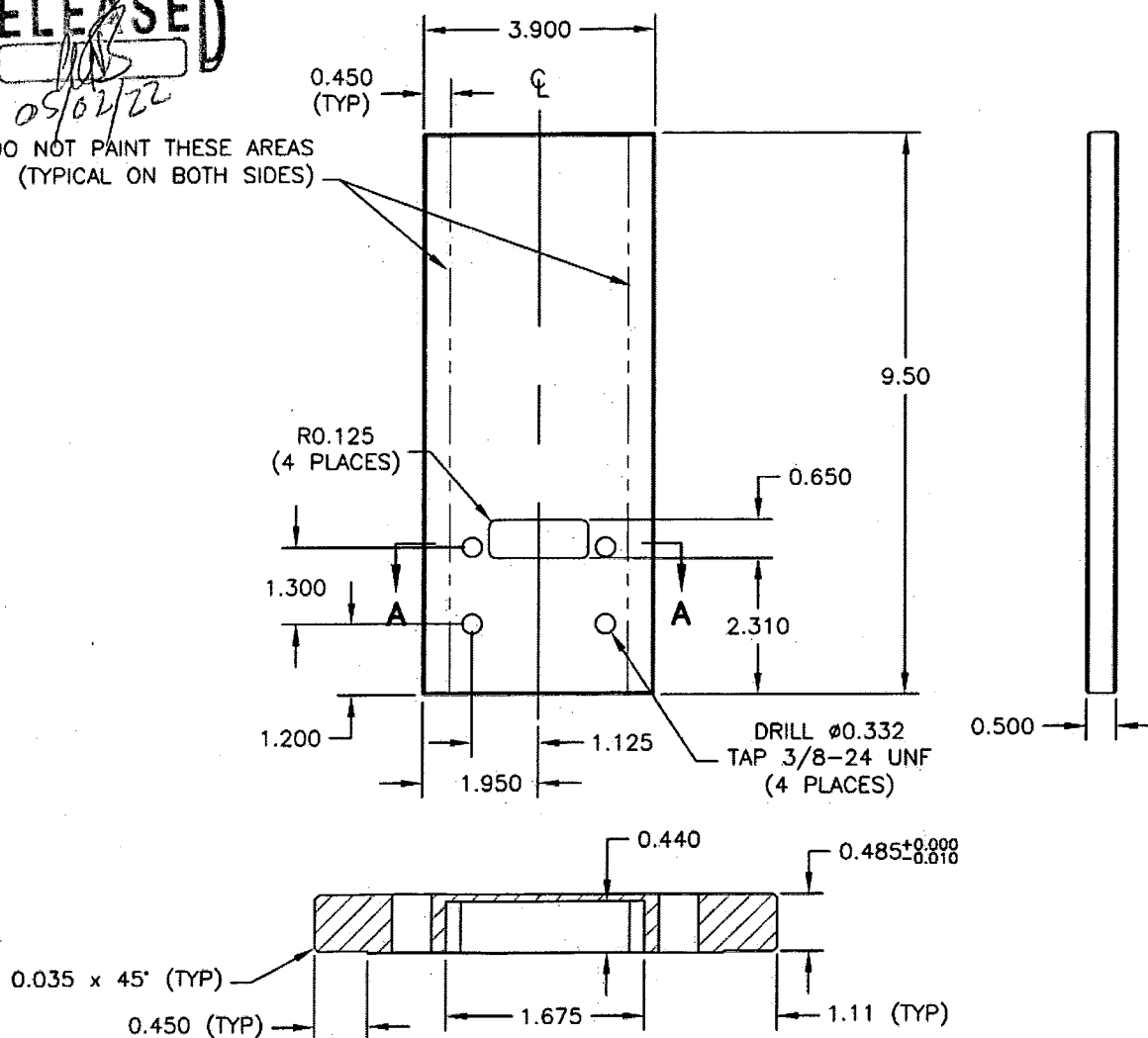
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(TYPICAL ON BOTH SIDES)



SECTION A-A

D3333-3 SLIDING PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 0.50 THICK
MILD STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

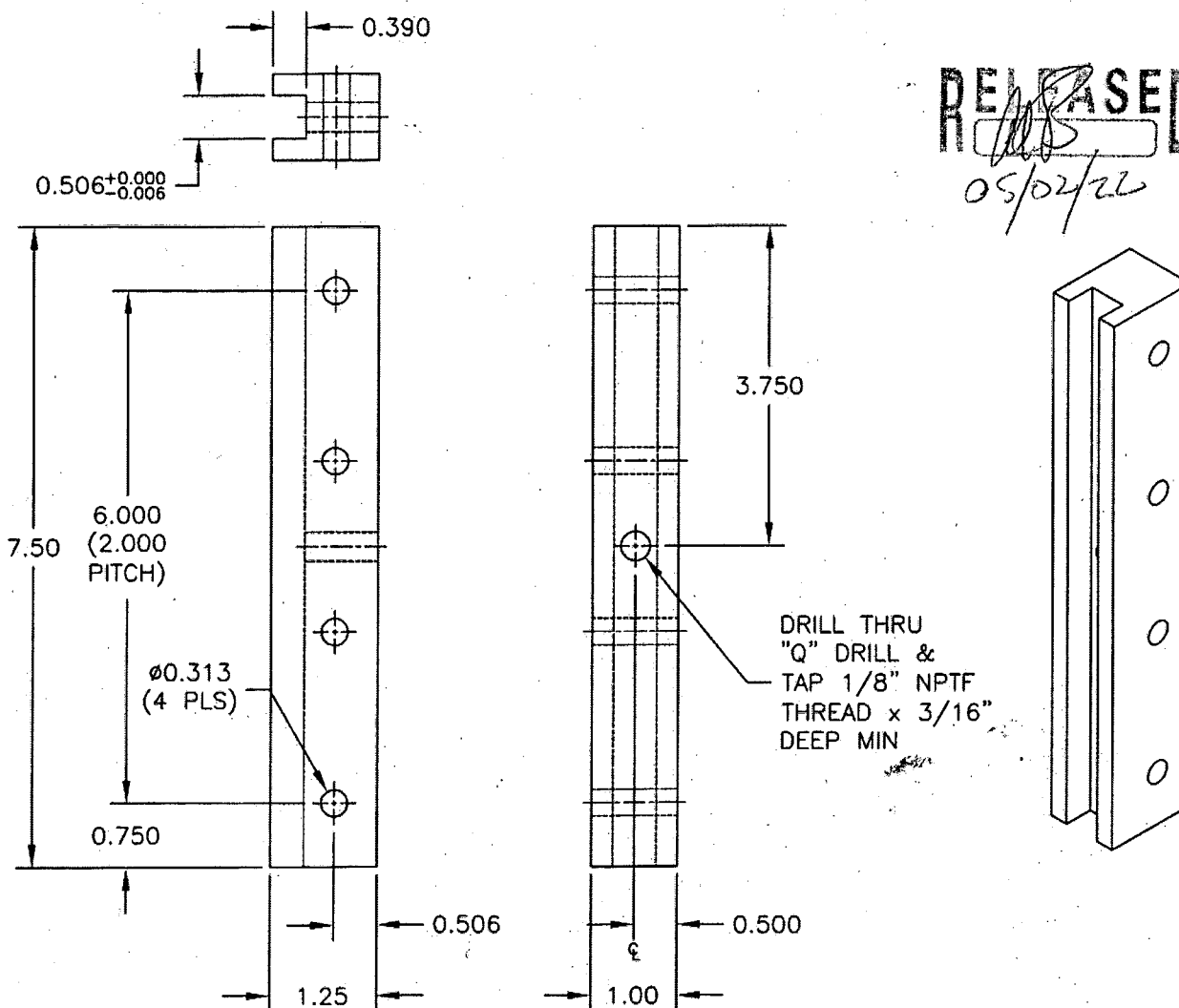
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CHECKED #	APPROVED #	DRAWING NO. D3333	REV. B SHEET 3 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:2



RELEASED
05/02/22

D3333-5 RAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.00 THICK STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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